

Work Order ID 71429

Monday, July 04, 2011 11:38:06 AM



Page 1

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MFDate: 11-07-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D4168

A

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-015 CHG 002

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QtyReject
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NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section H-H

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168, detail A

6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

9- Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side) open holes of detail D section H-H to 0.500" as per dwg D4168

10- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

BE 11/08/25

11/08/25

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

A/R Aluminum Rod batch: ☐ M117884

11-Grind welds flush as per Dwg D4168

86 11/08/25
RL 11/08/26

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 11/08/29

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/08/29



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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

①

B 4/08/29

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1

0

BBN/08/29

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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling section AL-AL to 0.625"
(total of 8 holes per side)
as per dwg D4168.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D4168.

3- Open float hole to 0.500" (4 per side) section AJ-AJ

Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG

4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes
section AJ-AJ per dwg D4168 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: 117516 ☐☐☐

exp. date: 12/01/15

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1
& QSI004

(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M117884

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 11/08/29

BE 11/08/29

BE 11/08/30

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Item ID: D350-636-015

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Setup Start



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Start Date: 7/5/2011 Start Qty: 1.00



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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D4168, section AL-AL

12- C'bore section CG-CG

13- Deburr holes

> BE 11/09/07



BB 11/09/06

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Sularlos

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sularlos

Memo

0.00

FO

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Work Order ID 71429

Monday, July 04, 2011 11:38:06 AM

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Item ID: D350-636-015

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Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011 Start Qty: 1.00

Required Date: 7/19/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1X Ø M-L 11/04/13

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
320 °F
2:30

1X Ø M-L 11/04/13

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

✓ Inspect for foreign object per QSI 024

1 Ø M-L 11/04/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220 | | 0.00 | | | | | | | |
| | HandFinishing | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install inserts as per Dwg D4168 | | | | | | | | |
| 230 | | 0.00 | | | | | | | |
| | HandFinishing | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Inspect for Foreign Objects | | | | | | | | |
| | 2-Spray inside of tube with "LPS-3" batch: <u>DIA</u> | | | | | | | | |
| | 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168 | | | | | | | | |
| | SIKA FLEX 241 | | | | | | | | |
| | BATCH: <u>1118393</u> | | | | | | | | |
| | EXP DATE: <u>12/01</u> | | | | | | | | |
| | 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube | | | | | | | | |
| | A/R 55-o'ring lube batch: <u>1110340</u> | | | | | | | | |
| | 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>11114596</u> | | | | | | | | |

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NOTE: Date & initial all entries

Work Order ID 71429

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Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Item Name: Skidtube STD w/ Training Wearplates, LH

Stop



Start Date: 7/5/2011 Start Qty: 1.00



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Run Start



Stop



Sequence ID/
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Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/15

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

If making a D350-636-215
pick kit will only requires:
1 X AN3C37A
1 X AN3C34A
1 X AN3C42A
2 X D3493-1

11/9/15 SP

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

8/10/16

40

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CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

71434



Packaging

Packaging

0.00

Memo

Identify and pack for shipping as per PPPD350-636-015

Location: _____

PPP rev: _____

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

Pupps e

n/a/20

ME 11-09-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Monday, July 04, 2011 11:38:02 AM

Page 1

Work Order ID: 71429

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC
11.04.14 ecn11-553 DD verf:EC

IPP Rev:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--|--|-----------|----|--|--|-----|------|---------|---|---|--|--|--|
| AN3C34A | | Purchased | No | | | 230 | Each | 22.0000 | 1 | 1 | | | |
|  | | | | | | | | | | | | | |
| BOLT | | | | | | | | | | | | | |


| Location | Loc Qty | Loc Code |
|----------|---------|----------|
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| | | |
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| ST352 | 20 | |
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| | | |
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| 117514 | 20 | |
|--------|----|--|

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|-------|---|--|
| ST353 | 2 | |
|-------|---|--|

| | | |
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| 116003 | 2 | |
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|--|--|-----------|----|--|--|-----|------|----------|---|---|--|--|--|
| AN3C36A | | Purchased | No | | | 230 | Each | 183.0000 | 4 | 4 | | | |
|  | | | | | | | | | | | | | |
| BOLT | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|----|----|--|
| FG | 14 | |
|----|----|--|

| | | |
|--------|---|--|
| 101261 | 4 | |
|--------|---|--|

| | | |
|--------|----|--|
| 116590 | 10 | |
|--------|----|--|

| | | |
|------|----|--|
| FP-B | 31 | |
|------|----|--|

| | | |
|--------|----|--|
| 111925 | 31 | |
|--------|----|--|

| | | |
|-------|---|--|
| ST303 | 8 | |
|-------|---|--|

| | | |
|--------|---|--|
| 116590 | 8 | |
|--------|---|--|

| | | |
|-------|-----|--|
| ST353 | 130 | |
|-------|-----|--|

| | | |
|--------|----|--|
| 117125 | 30 | |
|--------|----|--|

| | | |
|--------|----|--|
| 117872 | 50 | |
|--------|----|--|

| | | |
|--------|----|--|
| 118191 | 50 | |
|--------|----|--|

M116075 SD 11/9/15

1109111

xc

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, July 04, 2011 11:38:02 AM

Page 2

Work Order ID: 71429

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C37A

Purchased

No

230

Each

187.0000

1

1



BOLT



11/18/11

Location

Loc Qty

Loc Code

ST353

178

116874

11

117010

2

117763

25

117885

60

118159

80

ST354

9

117343

9

AN3C42A

Purchased

No

230

Each

61.0000

1

1



BOLT



11/9/11

Location

Loc Qty

Loc Code

ST354

61

106176

21

117763

20

118131

20

D3492-1

Manufactured

No

230

Each

132.0000

8

8



Plug



11/09/11

Location

Loc Qty

Loc Code

FP

132

69531

8

69819

52

70689

72

371836

v8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, July 04, 2011 11:38:02 AM

Work Order ID: 71429

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

124.0000

8

8



Plug

Location

Loc Qty

Loc Code

FP

124

B72126

x%

69822

44

70692

80

D3873-1

Manufactured No

230

Each

115.0000

7

7



Bushing

Location

Loc Qty

Loc Code

ST084

51

68247

51

ST088

64

x7

64760

1

70690

63

D4154-041

Manufactured No

230

Each

0.0000

1

1



Wearplate Assembly

B69812



(x1)

YU

11/09/11

D4170-1

Manufactured No

230

Each

19.0000

4

4



Bushing

Location

Loc Qty

Loc Code

LG

15

61581

5

68225

10

LG002

4

65912

4

4/

BE11/08/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, July 04, 2011 11:38:02 AM

Work Order ID: 71429

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4171-1 Manufactured No

230 Each

20.0000 1 1



Bushing



u104114

Location

Loc Qty

Loc Code

ST135

20

69037

20

MS21043-3

Purchased No

230 Each

1,153.000 5



u109114

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1081

112314

89

118077

992

NAS1149C0363R

Purchased No

230 Each

4,368.000 9



u109114

Washer

Location

Loc Qty

Loc Code

ST297

4368

114742

4368

NAS1515H3L

Purchased No

230 Each

224.0000 4



u109114

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

184

113362

184

1118686

X1

X3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, July 04, 2011 11:38:03 AM

Work Order ID: 71429

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

198.0000

8

8



O-RING



11/09/11

Location

Loc Qty

Loc Code

FP

96

117460

16

118077

80

1118612

x8

FP-A

102

110915

91

115589

11

NAS1611-013

Purchased

No

230

Each

176.0000

8

8



O-RING



11/09/11

Location

Loc Qty

Loc Code

FP

171

117291

31

117887

140

1118384

x8

FP-A

5

116582

5

AN960JD816

Purchased

No

250

Each

1.0000

2

2



1/2" washer, Alum

*NAS1149008635

↓



11/09/11

Location

Loc Qty

Loc Code

FP-A

1

106043

1

1118078

x2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71429

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

5.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002

5

62715

1

65086

4

D2600-3-BENT

Manufactured No

110

Each

18.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

18

66875

8

68137

1

70142

9

D2743

Manufactured No

160

Each

163.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

105

69818

105

LG001

58

67766

4

68251

54

D2739

Manufactured No

160

Each

5.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

5

69886

5

BE 11/05/25
B 70881 x1

1
1
B 11/08/25

BE 11/08/30

BE 11/09/29
B70823 x1

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71429



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each

77.0000

4

4



Cross Bolt Spacer



BE 11/08/30

Location

Loc Qty

Loc Code

LG

77

68952

18

70768

59

4

D3490-1 Manufactured No

160 Each

97.0000

4

4



Cross Bolt Spacer



BE 11/08/30

Location

Loc Qty

Loc Code

LG

95

67773

5

69510

30

69823

60

4

LG001

2

62450

2

ALS4-1032-225 Purchased No

230 Each

622.0000

4

4



Insert



BE 11/09/14

Location

Loc Qty

Loc Code

ST282

622

110768

213

117717

409

AL 118696

x4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71429



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

83.0000

1

1



BOLT



xl 4/09/14

Location

Loc Qty

Loc Code

FP

40

117511

40

xl

FP-A

8

115960

1

116874

7

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

D3488-041

Manufactured

No

230

Each

8.0000

1

1



xl 4/09/14

Blade Fitting Assembly, LH

Location

Loc Qty

Loc Code

FP007

1

61689

1

FP008

7

67788

6

68108

1

B71887

xl

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71429

Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011



Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|--|-----------|----|-----|------|---------|---|-------------------------|
| AN6C44A | Purchased | No | 230 | Each | 85.0000 | 4 | 4 |
|  | | | | | |  | <u>4</u> <u>u/og/14</u> |
| BOLT | | | | | | | |



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|--------|----|---------|
| FG | 2 | |
| 103964 | 2 | xx18332 |
| ST344 | 83 | |
| 117763 | 31 | |
| 117950 | 50 | |
| 118112 | 2 | |

| | | | | | | | |
|--|-----------|----|-----|------|---------|---|-------------------------|
| MS21083C8 | Purchased | No | 230 | Each | 97.0000 | 1 | 1 |
|  | | | | | |  | <u>1</u> <u>u/og/14</u> |
| NUT | | | | | | | |



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|--------|----|--|
| FP-B | 1 | |
| 115884 | 1 | |
| ST293 | 50 | |
| 118077 | 50 | |
| ST303 | 46 | |
| 115884 | 0 | |
| 117423 | 25 | |
| 117677 | 21 | |

| | | | | | | | |
|--|--------------|----|-----|------|----------|---|-------------------------|
| D3631-1 | Manufactured | No | 230 | Each | 387.0000 | 8 | 8 |
|  | | | | | |  | <u>8</u> <u>u/og/14</u> |
| Washer | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-------|-----|--|
| ST072 | 387 | |
| 68062 | 387 | |

| | | | | | | | |
|--|-----------|----|-----|------|--------|---|-------------------------|
| AN960C10L | Purchased | No | 230 | Each | 0.0000 | 4 | 4 |
|  | | | | | |  | <u>4</u> <u>u/og/14</u> |
| washer | | | | | | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71429



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

276.0000

8

8



Bushing



u

u/09/14

Location

Loc Qty

Loc Code

FP-A

276

68248

41

69529

155

69816

80

x 8

AN960C816L

Purchased No

230

Each

0.0000

1

1



X NAS149C0832R / M111915



(x1) u

u/09/14

WASHER

AN3C6A

Purchased No

230

Each

240.0000

4

4



u

u/09/14

BOLT

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

239

111982

2

116419

23

116549

2

116704

12

117619

50

117688

100

117872

50

y4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 71429

Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011



Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 445.0000 4 4

 NUT  u/og/14



Location Loc Qty Loc Code

FG 20
 103693 20
 ST301 425
112314 415
 117887 10

D3493-1 Manufactured No 250 Each 83.0000 2 2

 Washer  1/9/12

Location Loc Qty Loc Code

ST062 83
 68253 23
70697 60

MS21083C8 Purchased No 250 Each 97.0000 2 2

 NUT  u/og/14

Location Loc Qty Loc Code

FP-B 1
 115884 1
 ST293 50
118077 50
 ST303 46
 115884 0
 117423 25
 117677 21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71429



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

101.0000

2

2



11/09/11

BOLT

Location

Loc Qty

Loc Code

ST344

25

117764

25

ST345

76

117562

26

118045

50

1118045

12

D2741

Manufactured

No

250

Each

39.0000

1

1



11/09/11

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

39

63589

9

69133

30

11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

71429

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2010-09-15

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|---------------------------|
| X | | | | D4168-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | X | | | D4168-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | X | | D4168-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D4168-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 7 | 7 | 7 | 7 | D3873-1 | BUSHING |
| 1 | 1 | 1 | 1 | D4154-041 | WEARPLATE ASSEMBLY |
| 1 | | | | D4168-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D4168-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D4168-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D4168-4 | SKIDTUBE WELDMENT, RH |
| 4 | 4 | 4 | 4 | D4170-1 | SPACER |
| 1 | 1 | 1 | 1 | D4171-1 | BUSHING |
| 4 | 4 | 4 | 4 | ALS4-1032-225 | INSERT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 1 | 1 | 1 | 1 | AN3C34A | BOLT |
| 4 | 4 | 4 | 4 | AN3C36A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 9 | 9 | 9 | 9 | AN960C10 | WASHER (OR NAS1149CO363R) |
| 4 | 4 | 4 | 4 | AN960C10L | WASHER (OR NAS1149CO332R) |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER (OR NAS1149CO832R) |
| 5 | 5 | 5 | 5 | MS21043-3 | NUT |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

GENERAL NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

| | | | |
|-------------|-------------|---|---------------|
| A NEW ISSUE | | SC | 10.08.09 |
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| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4168 | SHEET 1 OF 11 |
| APPROVED | | TITLE | SCALE |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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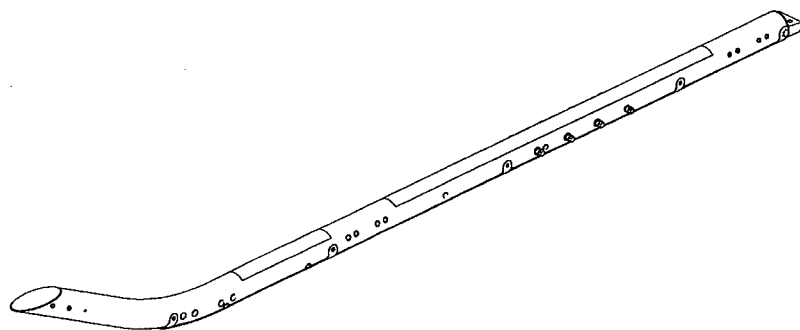
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

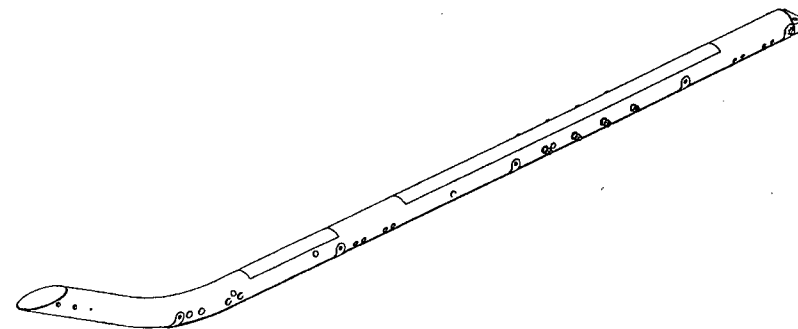
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D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

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| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D4168 | SHEET 2 OF 11 |
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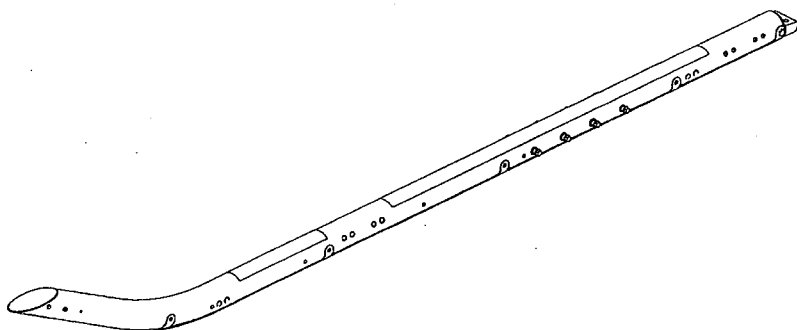
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

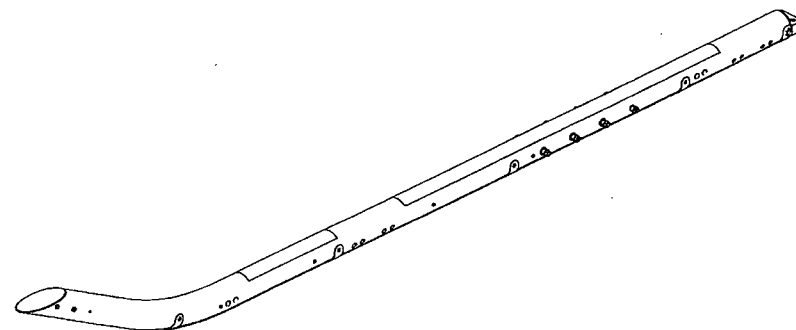
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NOTE: Date & initial all entries

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D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

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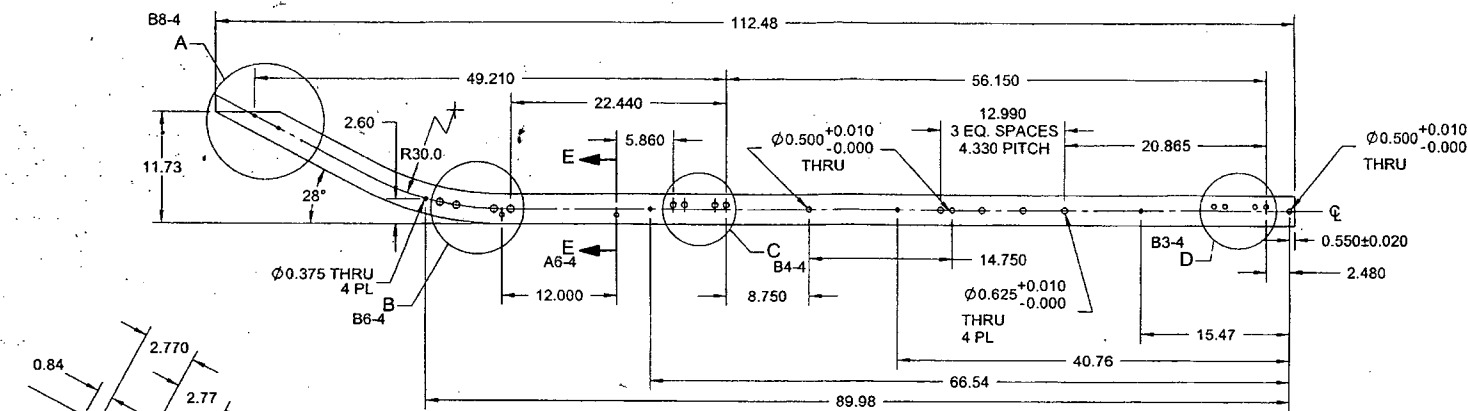
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

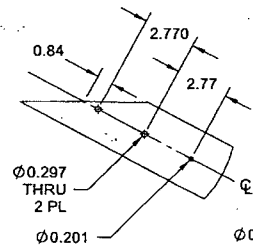
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NOTE: Date & initial all entries

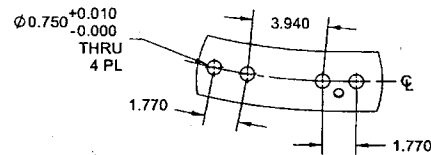
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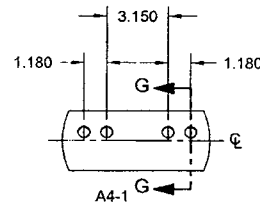
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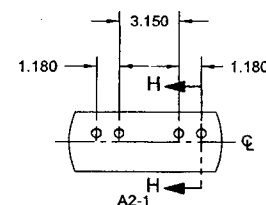
DETAIL A
SCALE 2X



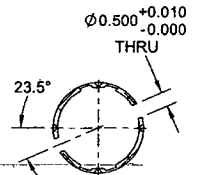
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SCALE 2X



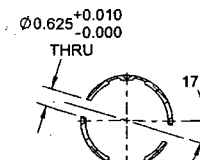
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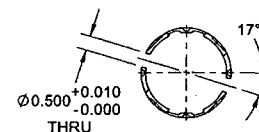
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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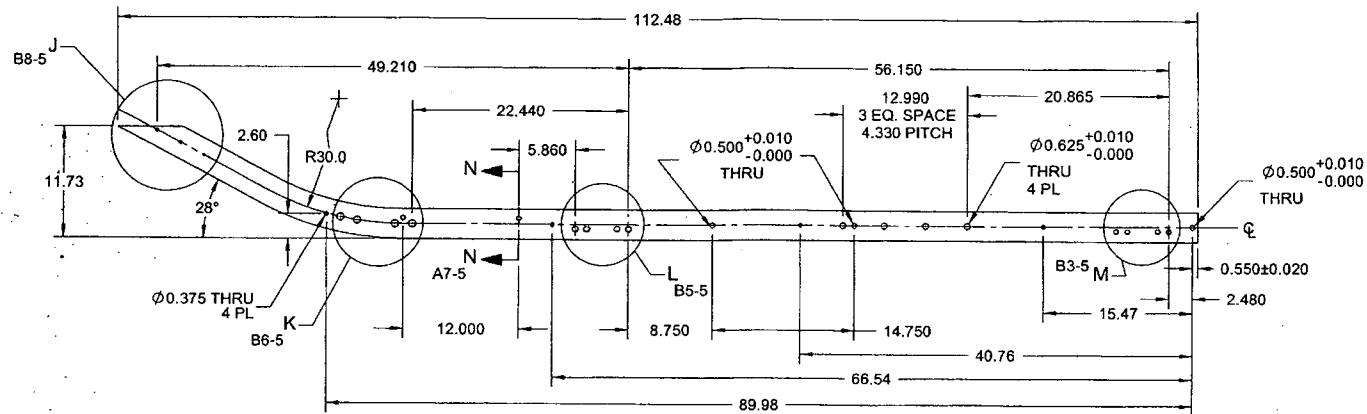
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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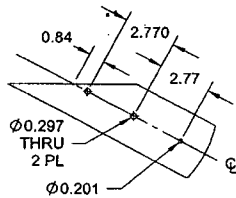
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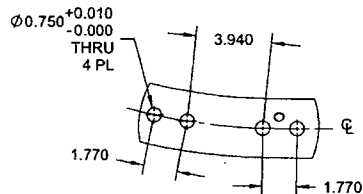
NOTE: Date & initial all entries



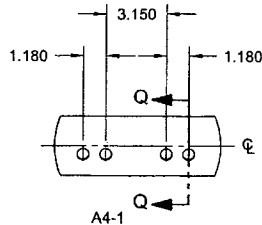
D4168-2 RH SKIDTUBE



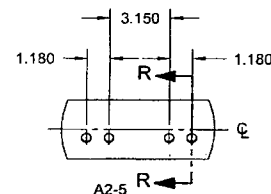
DETAIL J
SCALE 2X



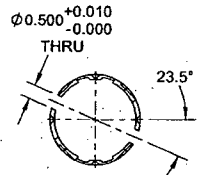
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SCALE 2X



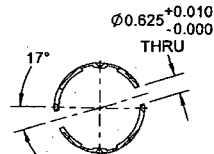
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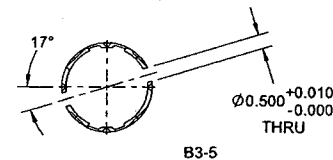
DETAIL M
SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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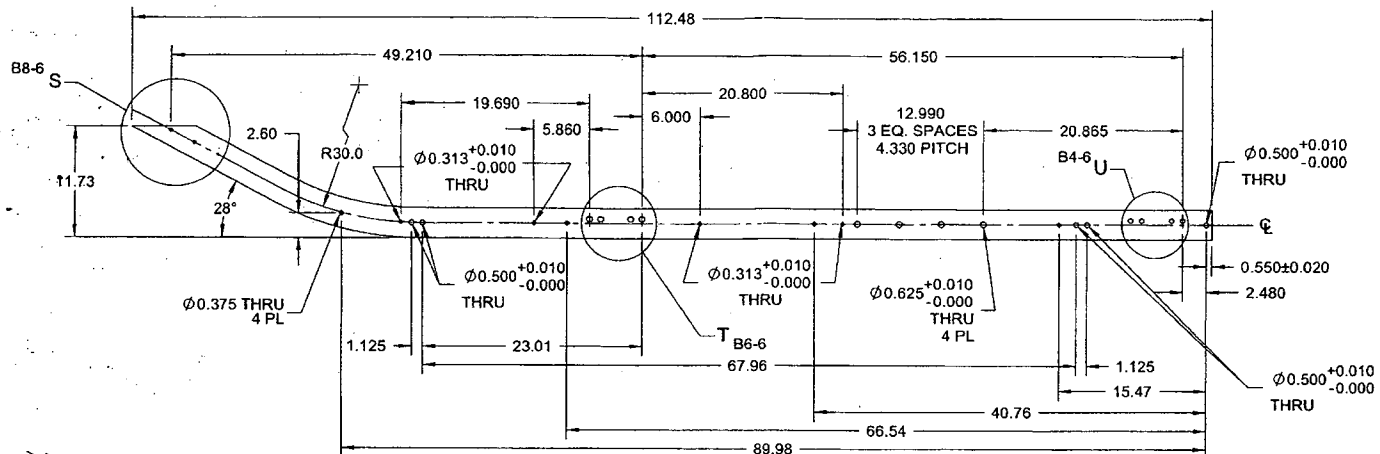
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

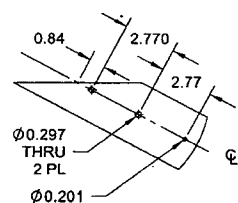
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NOTE: Date & initial all entries

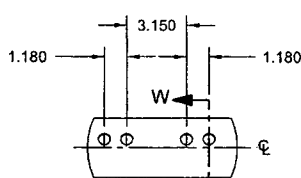
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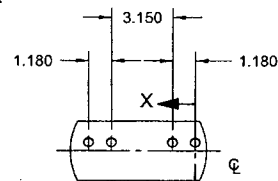
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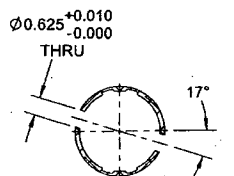
DETAIL S
SCALE 2X
D8-6



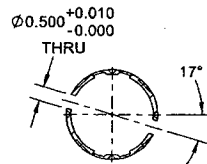
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C5-6



DETAIL U
SCALE 2X
D3-6



SECTION W-W
SCALE 3X, 4 PL
B6-6



SECTION X-X
SCALE 3X, 4 PL
B4-6

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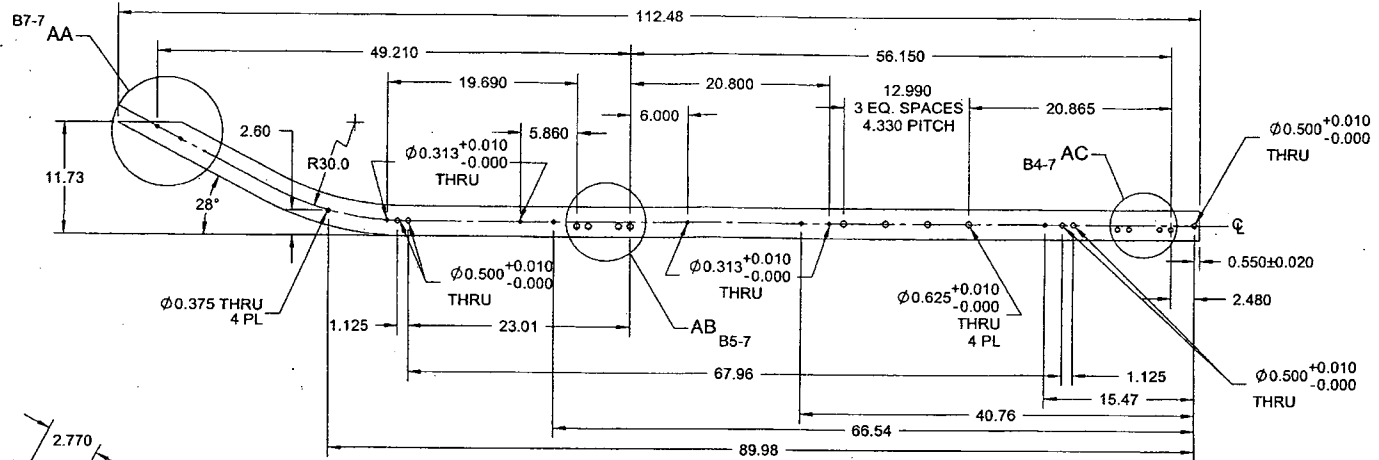
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

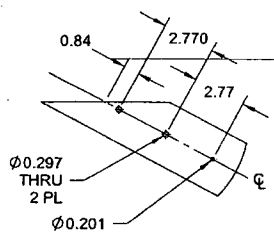
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NOTE: Date & initial all entries

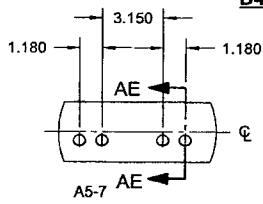
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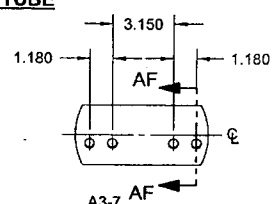
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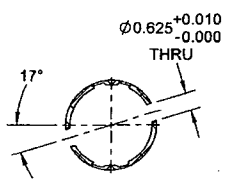
DETAIL AA
SCALE 2X



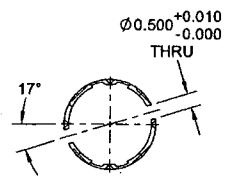
DETAIL AB
SCALE 2X



DETAIL AC
SCALE 2X



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED
2010-09-16

| | | | |
|------------|----------|---|---------------|
| DESIGN | SC | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4168 | SHEET 7 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
| DATE | 10.08.09 | <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

8 7 6 5 4 3 2 1

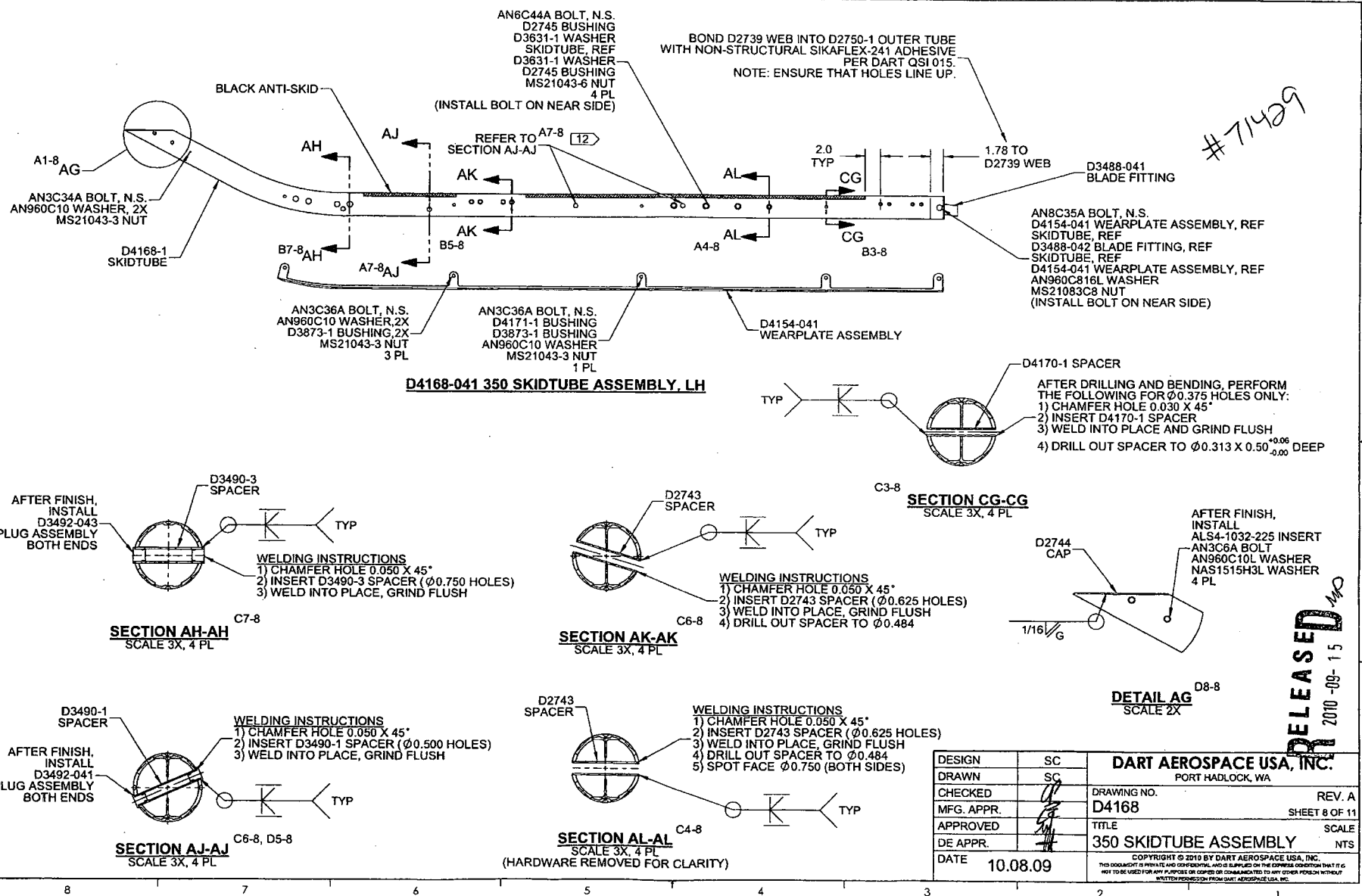
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

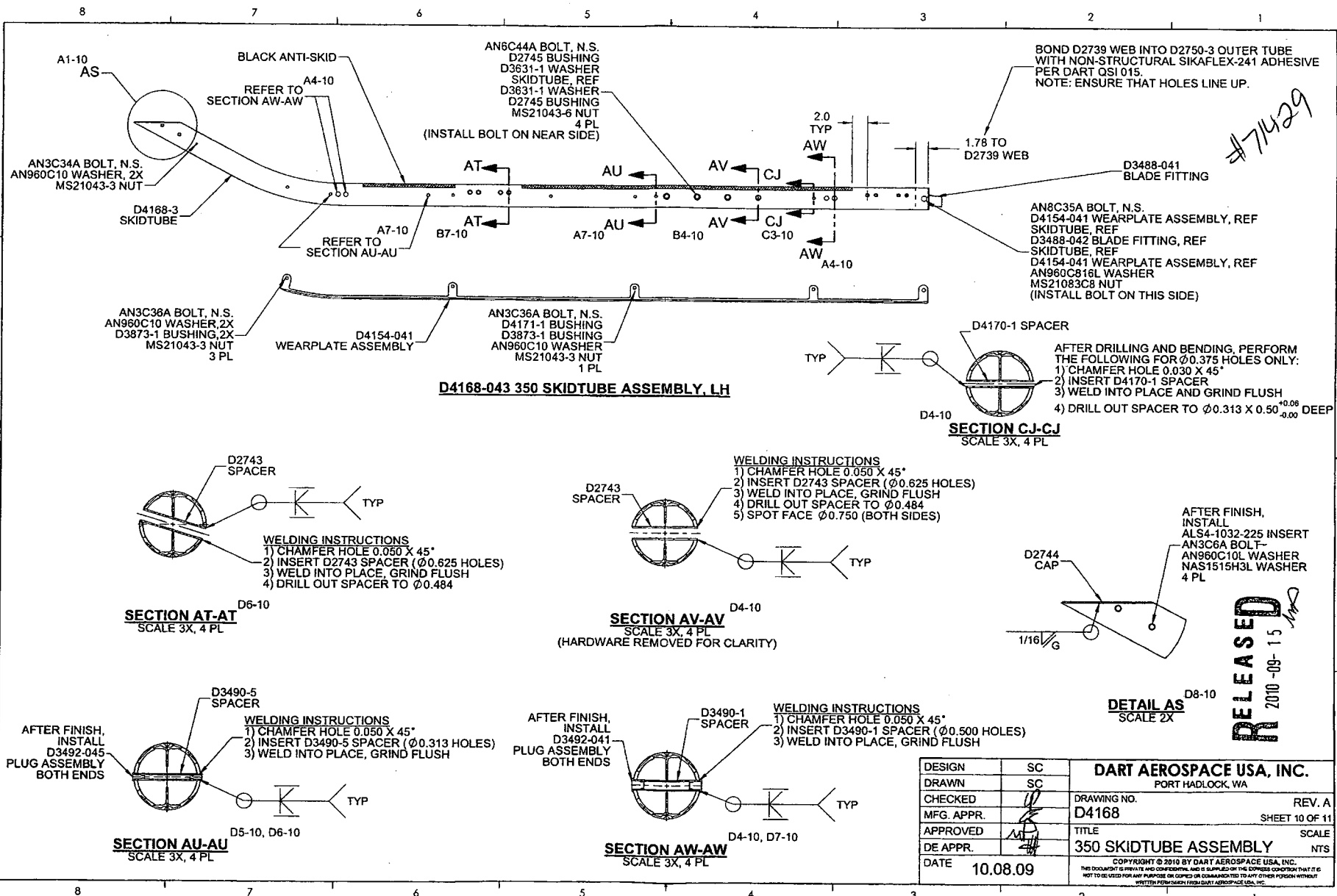
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



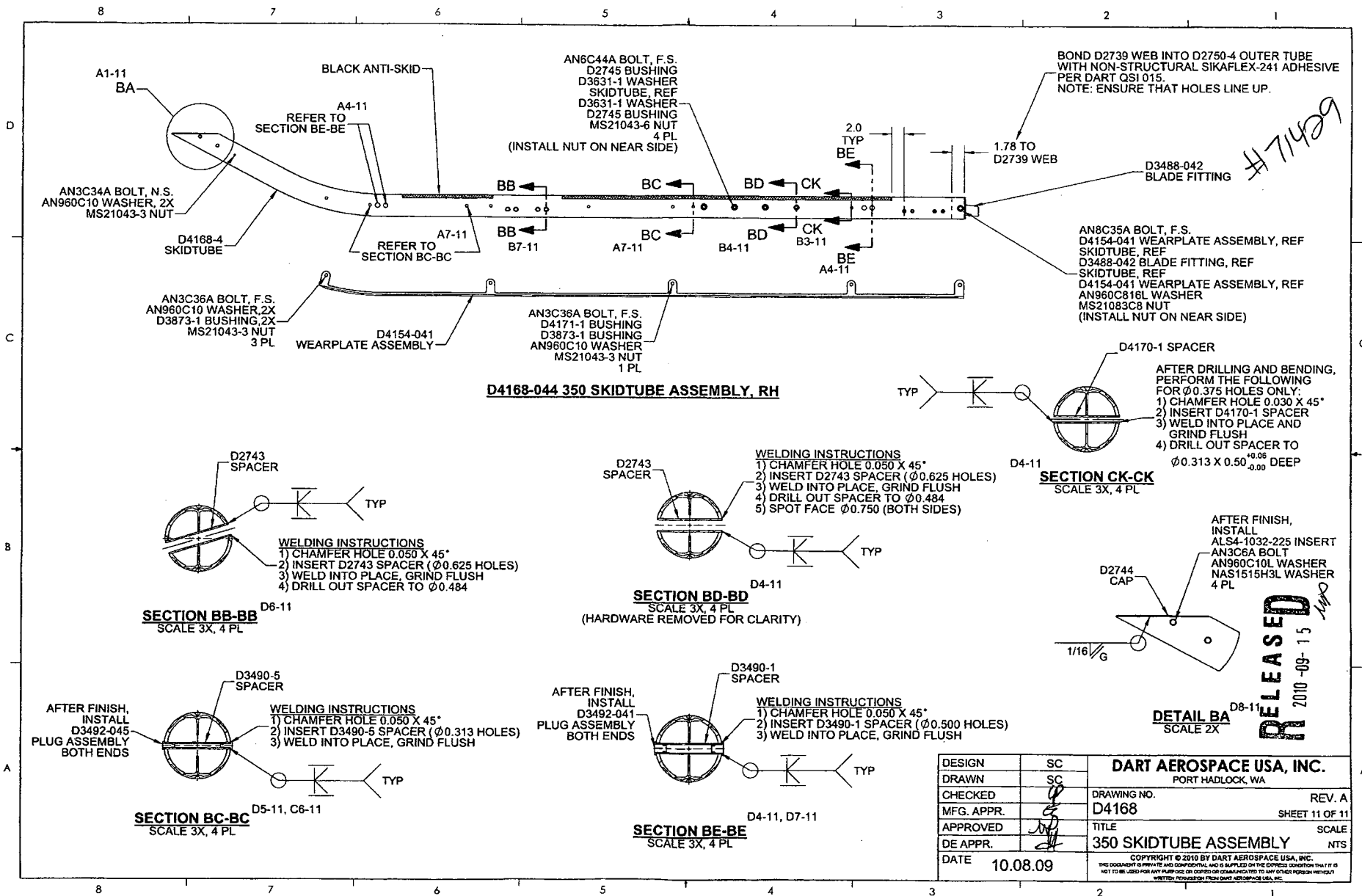
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



RELEASED
2010-09-15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

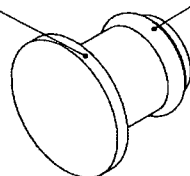
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X | | | | | | | D3492-041 | PLUG ASSEMBLY |
| | X | | | | | | D3492-043 | PLUG ASSEMBLY |
| | | X | | | | | D3492-045 | PLUG ASSEMBLY |
| | | | X | | | | D3492-047 | PLUG ASSEMBLY |
| | | | | X | | | D3492-049 | PLUG ASSEMBLY |
| | | | | | X | | D3492-051 | PLUG ASSEMBLY |
| | | | | | | X | D3492-053 | PLUG ASSEMBLY |
| 1 | | | | | | | D3492-1 | PLUG |
| | 1 | | | | | | D3492-3 | PLUG |
| | | 1 | | | | | D3492-5 | PLUG |
| | | | 1 | | | | D3492-7 | PLUG |
| | | | | 1 | | | D3492-9 | PLUG |
| | | | | | 1 | | D3492-11 | PLUG |
| | | | | | | 1 | D3492-13 | PLUG |
| | | 1 | | | | | NAS1611-005 | O-RING |
| | | | 1 | | | | NAS1611-007 | O-RING |
| 1 | | | | | | | NAS1611-010 | O-RING |
| | | | | | | 1 | NAS1611-012 | O-RING |
| | 1 | | | | | | NAS1611-013 | O-RING |
| | | | | | 1 | | NAS1611-015 | O-RING |
| | | | | 1 | | | NAS1611-016 | O-RING |

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2011-05-30

| | | | |
|------------|---|--|--------------|
| D | INCORPORATED DEC D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-049) | AJS | 11.05.24 |
| C | ADD -049/-051/-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B | ADD -047; UPDATE DIM A FOR -045 | PH | 08.05.11 |
| A | NEW ISSUE | PH | 08.01.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | AJS | DRAWING NO. | REV. D |
| MFG. APPR. | JFZ | D3492 | SHEET 1 OF 2 |
| APPROVED | AJS | TITLE | SCALE |
| DE APPR. | AJS | PLUG | 2:1 |
| DATE | 11.05.24 | <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

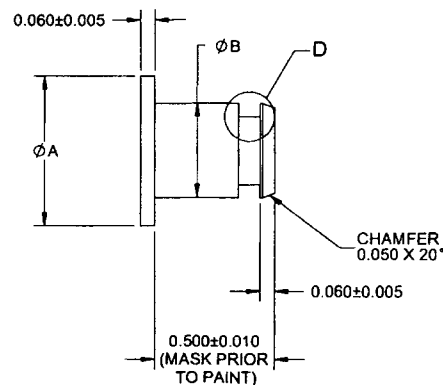
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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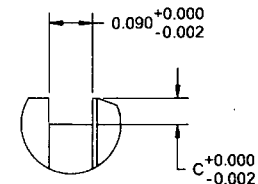
NOTE: Date & initial all entries



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC | |
|----------|-------|-------|-------|---------------|---|
| D3492-1 | 0.625 | 0.394 | 0.050 | M6061T6R0.625 | △ |
| D3492-3 | 0.750 | 0.582 | 0.045 | M6061T6R0.750 | |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.375 | |
| D3492-7 | 0.500 | 0.270 | 0.045 | M6061T6R0.500 | |
| D3492-9 | 0.938 | 0.750 | 0.045 | M6061T6R1.000 | |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 | |
| D3492-13 | 0.750 | 0.510 | 0.045 | M6061T6R0.750 | △ |

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2011-05-30

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | JES | D3492 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | PLUG | 4:1 |
| DATE | 11.05.24 | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 265

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 714270
Part number: J 350 636 015
Description: 350
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal Luy Date of Test Coupon 11.09.06
Welder Barclay Elliott Date of Test Coupon 11.09.06

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries